

*Date: Tuesday, 21/10/2008 2:45:16 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206 GHW ADAPTER
Job Number : 42767	
Estimate Number : 10571	
P.O. Number :	Part Number : D206651041
This Issue : 21/10/2008 S.O. No. :	Drawing Number : D2711/D2690
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A / B2
Previous Run : 37451	Material :
Written By :	Due Date : 15/11/2008 Qty: 5 Um: Each
Checked & Approved By : JUD 08.10.21	
Comment : Est Rev: F 02.08.14 Re-format KJ Est Rev: G Removed Purchasing 07-03-21 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D206-651-041 CHG001

2.0	D2692	Spring Pin Clip
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2692	Spring pin	B34682

SO

3.0	D2711	Lock Pin
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2711	Pin	B37461

SO

4.0	AN960JD10	Washer
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**Comment:** Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN960JD10	Washer	M109059

8/10/23

SO

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 GHW ADAPTER

Job Number: 42767

Part Number: D206651041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	CBL1240	Cable
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Comment: Qty.: 1.7500 f(s)/Unit Total: 8.7500 f(s)

Pick:

Qty	Part Number	Description	Batch
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21"	CBL-1240	Cable	M107234
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SL

6.0	CBL460	Loop Sleeve
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
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4	CBL-460	Loop sleeve	M109060
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SL

7.0	MS21042L3	Nut
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
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2	MS21042L3	Nut	M109031
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SL

8.0	MS27039108	Screw
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
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2	MS27039-1-08	Screw	M107370
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SL

SL

9.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut cable CBL-1240 in half (10.5" each) Remove 2.25" of sleeve from each end of cable CBL-1240

2-Crimp CBL-460 onto CBL-1240 to make (2) D2690-8 as per Dwg D2690. (Leave one end open)

3-Install Lanyard D2690-8 (from open end) into pin D2711 and assemble screw, washer and nut as per Dwg D206-651.

4-Install Lanyard D2690-8 into spring pin D2692 and assemble screw, washer and nut at other loop as per Dwg D206-651.

FF

08/10/28

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 21/10/2008 2:45:16 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 GHW ADAPTER

Job Number: 42767

Part Number: D206651041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC5

INSPECT WORK TO CURRENT STEP



(Ph)

Comment: INSPECT WORK TO CURRENT STEP

508/10/28 (+5)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



(5x)

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-651-041 CHG001

Location: PR

PPP Rev: A

8/10/29

34

12.0

QC21

FINAL INSPECTION/W/O RELEASE



(5)

Comment: FINAL INSPECTION/W/O RELEASE

508/10/29

Job Completion



408/10.29

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D26-651-041 PAR #: N/A Fault Category: Prod / Pkg. Pcs ^{mod & small} NCR: Yes No DQA: 1/1 Date: 08.11.11
Scrap / scrap QA: N/C Closed: KJ Date: 08/11/11

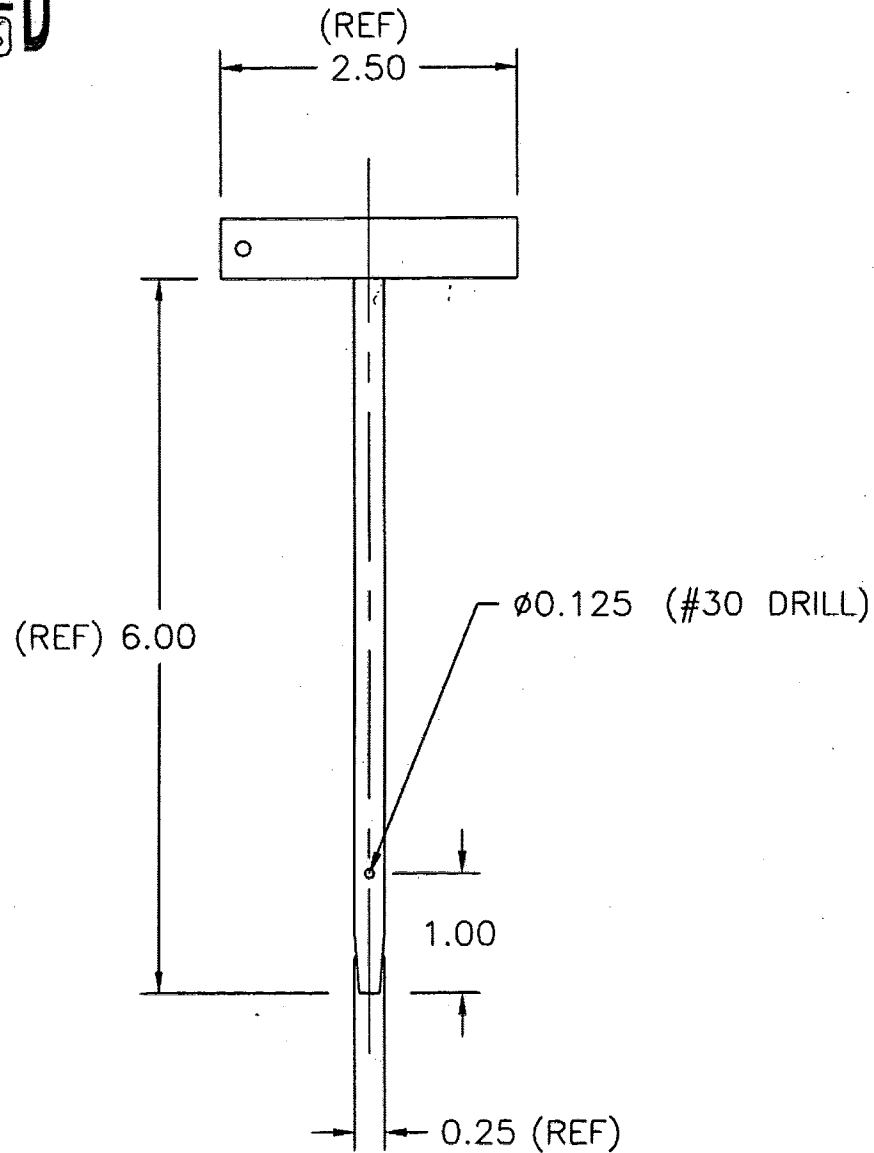
NCR: <u>42767</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>8/10/28</u>	<u>#</u> <u>W.O.</u>	<u>During inspection it was</u> <u>noticed that all D2690-8</u> <u>brackets were cut too short.</u> <u>R.C. employee miss read</u> <u>the work order.</u>	<u>0810.28</u>	<u>Scrap and destroy all</u> <u>Qty Qty <u>(x10)</u> D2690-8.</u> <u>Replace CBL-460 B*109062 <u>(x75)</u></u> <u>CBL-1240 B*1107234</u>	<u>FF</u> <u>08/10/28</u>	<u>S</u> <u>08/10/28</u>	<u>0810.28</u>	<u>S</u> <u>08/10/28</u>

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2711	REV. A SHEET 1 OF 1
DATE 97.11.03		TITLE LOCK PIN	SCALE NTS
A	97.11.03	NEW ISSUE	

RELEASED
97/11/06 DS



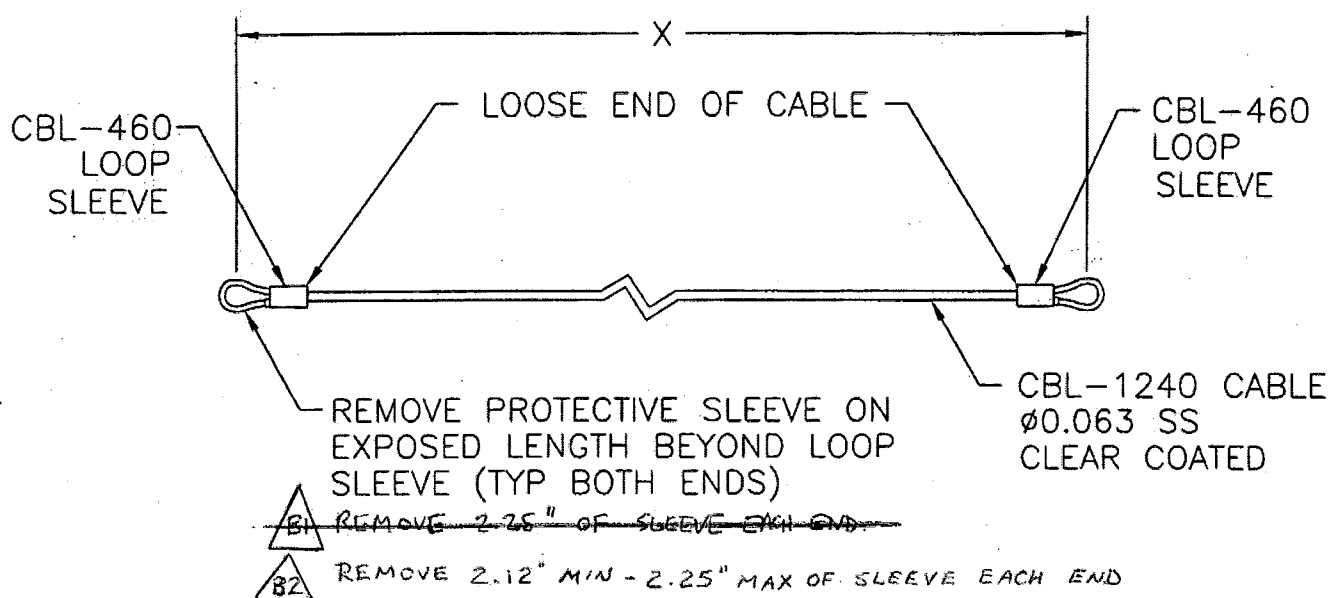
MAKE FROM REID TOOL SUPPLY PART # PNT-9
FINISH: CAD PLATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 42767



DESIGN <i>ME</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>ME</i>	APPROVED <i>BW</i>	DRAWING NO. D2690	REV. B SHEET 1 OF 1
DATE 97.10.02		TITLE LANYARD ASSEMBLY	SCALE NTS
A	97.07.03	NEW ISSUE	
B	97.10.02	REVISED NOTE FOR ADDITIONAL LENGTH	
B1	# CP 01.08.20	ADD NOTE TO REMOVE 2.25" OF SLEEVE	
B2	# 04.06.24	ADDED TOLERANCE	

RELEASED
971003 KE
TSR A374



D2690-X

X = LENGTH IN INCHES

NOTE: CUT CABLE 2.50* INCHES LONGER THAN 'X' LENGTH. FOLD ENDS TIGHT TO 'X' LENGTH AND CRIMP WITH SLEEVE AT END OF LOOSE END OF CABLE WITH CBL-705 CRIMPING TOOL.

*ADDITIONAL LENGTH MAY BE NECESSARY IN SOME APPLICATIONS. CUT AS REQUIRED.

NOTE: IN SOME CASES, END HAS TO BE CRIMPED AFTER ASSEMBLY WITH ATTACHING PARTS.

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 42767

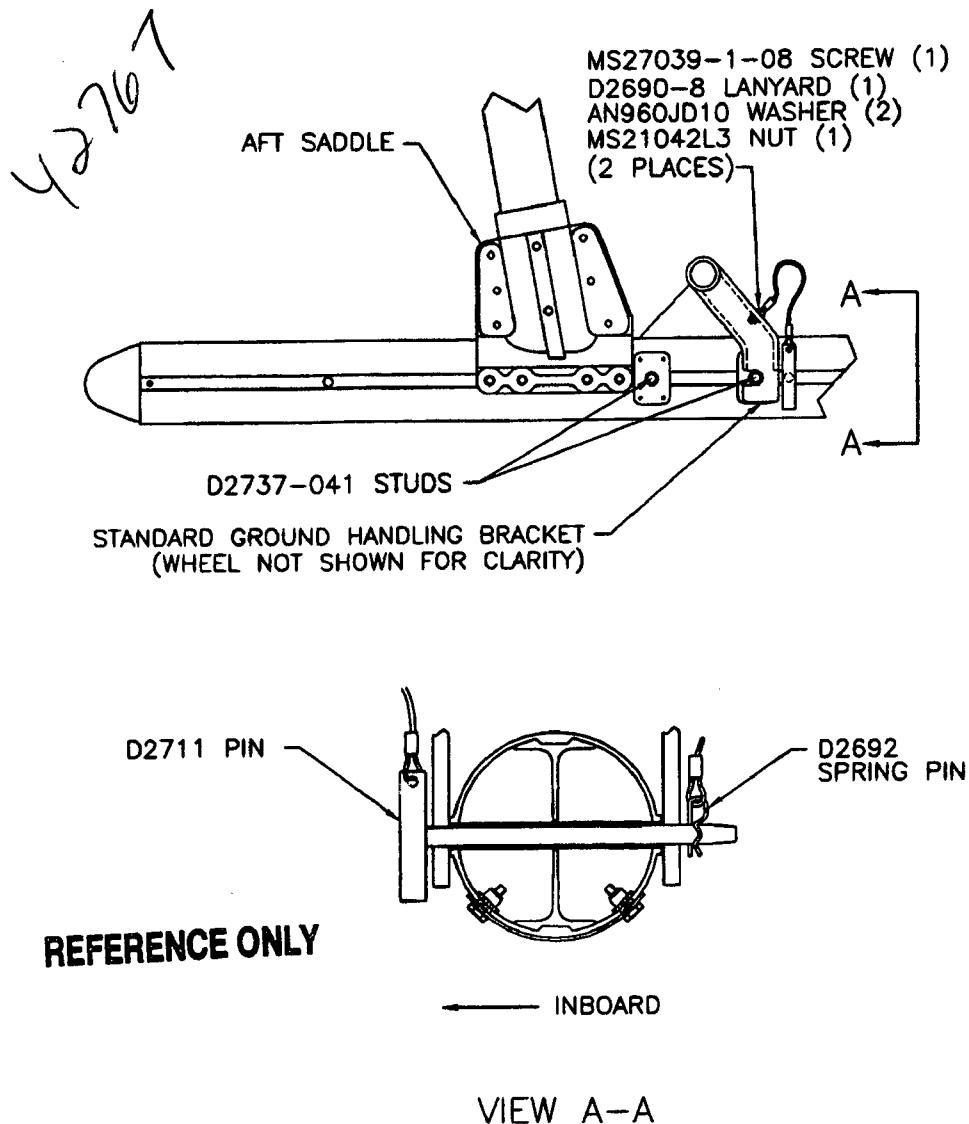
DEO's

DART

DESIGN <i>mm</i>	DRAWN BY <i>mm</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>KE</i>	APPROVED <i>JS</i>	DRAWING NO. D206-651	REV. B SHEET 1 OF 1
DATE 98.01.27		TITLE GND. HANDLING WHEEL (GHW) INST.	SCALE NTS
A	97.11.03	NEW ISSUE	
B	98.01.27	D2688 REPLACED BY D2737-041	

TO ADAPT STANDARD BELL GROUND HANDLING WHEELS TO DART 206A/B SKIDTUBES:

1. ATTACH D2711 PIN AND D2692 SPRING PIN TO THE GROUND HANDLING BRACKET BY DRILLING $\emptyset 0.191$ HOLES IN THE FWD FACE OF THE BRACKET AND USING THE LANDYARDS AND HARDWARE PROVIDED.
2. THE STANDARD BRACKET PICKS UP ON THE STUDS IN FRONT OF THE AFT SADDLE. SLIDE INTO PLACE AND INSTALL THE PIN SUPPLIED TO PREVENT THE UNIT FROM SLIPPING DURING GROUND HANDLING (SEE BELOW).
3. GROUND HANDLE IN THE NORMAL FASHION.
4. REMOVE THE BRACKET FOR FLIGHT. LEAVE THE PINS ATTACHED TO THE BRACKET.



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Date: Tuesday, 21/10/2008 3:03:57 PM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	206 GHW ADAPTER
Job Number :	42767		
Estimate Number :	10571		
P.O. Number :		Part Number :	D206651041
This Issue :	21/10/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2711/D2690
First Issue :	21/10/2008	Project Number :	N/A
Previous Run :	37451	Drawing Revision :	A / B2
		Material :	
Written By :		Due Date :	15/11/2008
Checked & Approved By :		Qty:	5 Um: Each
Comment :	Est Rev: F 02.08.14 Re-format KJ Est Rev: G Removed Purchasing 07-03-21 JLM		

Additional Product

REFERENCE ONLY

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

DC

DOCUMENT CONTROL



JLD 08-10-29



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D206-651-041 CHG001

2.0

D2692

Spring Pin Clip



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2692	Spring pin	

3.0

D2711

Lock Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2711	Pin	

Job Completion

